

Date: Monday, 7/9/2007 11:53:04 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 33398	
Estimate Number : 12766	
P.O. Number : N/A	Part Number : D35753
This Issue : 7/9/2007 S.O. No. : N/A	Drawing Number : D3575 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 31001	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 7/13/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 3 Um: Each
Comment : Est Rev. A New Issue 07-01-22 EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	F60029	lexan grey
-----	--------	------------



Comment: Qty.: 16.0000 sf(s)/Unit Total : 48.0000 sf(s)

F60029 lexan sheet

Batch: M 103 106

IB 07-07-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3575

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 07-07-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

In 07/07/12

(X3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary:

SB 07/07/13

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/11/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:53:04 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 33398

Part Number: D35753

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/07/13 x3

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/07/13 (3)

8.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

(3)  
07/07/13

Job Completion



07/07/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

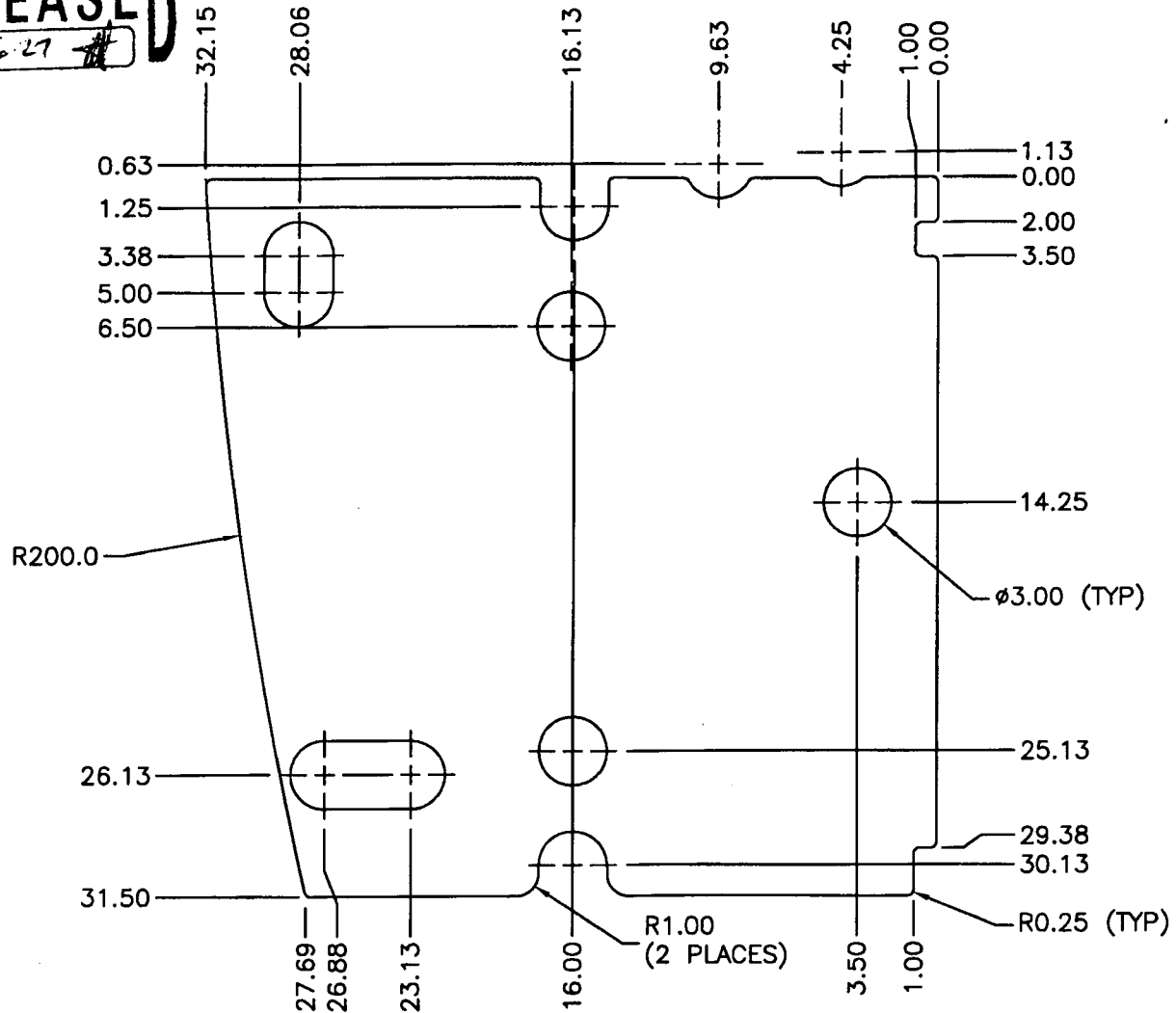
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3575	REV. A SHEET 1 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8
A	07.06.08	NEW ISSUE	

**RELEASED**  
07.06.27 *[Signature]*

**D3575-1 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-2 CABIN FLOOR PROTECTOR (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8966

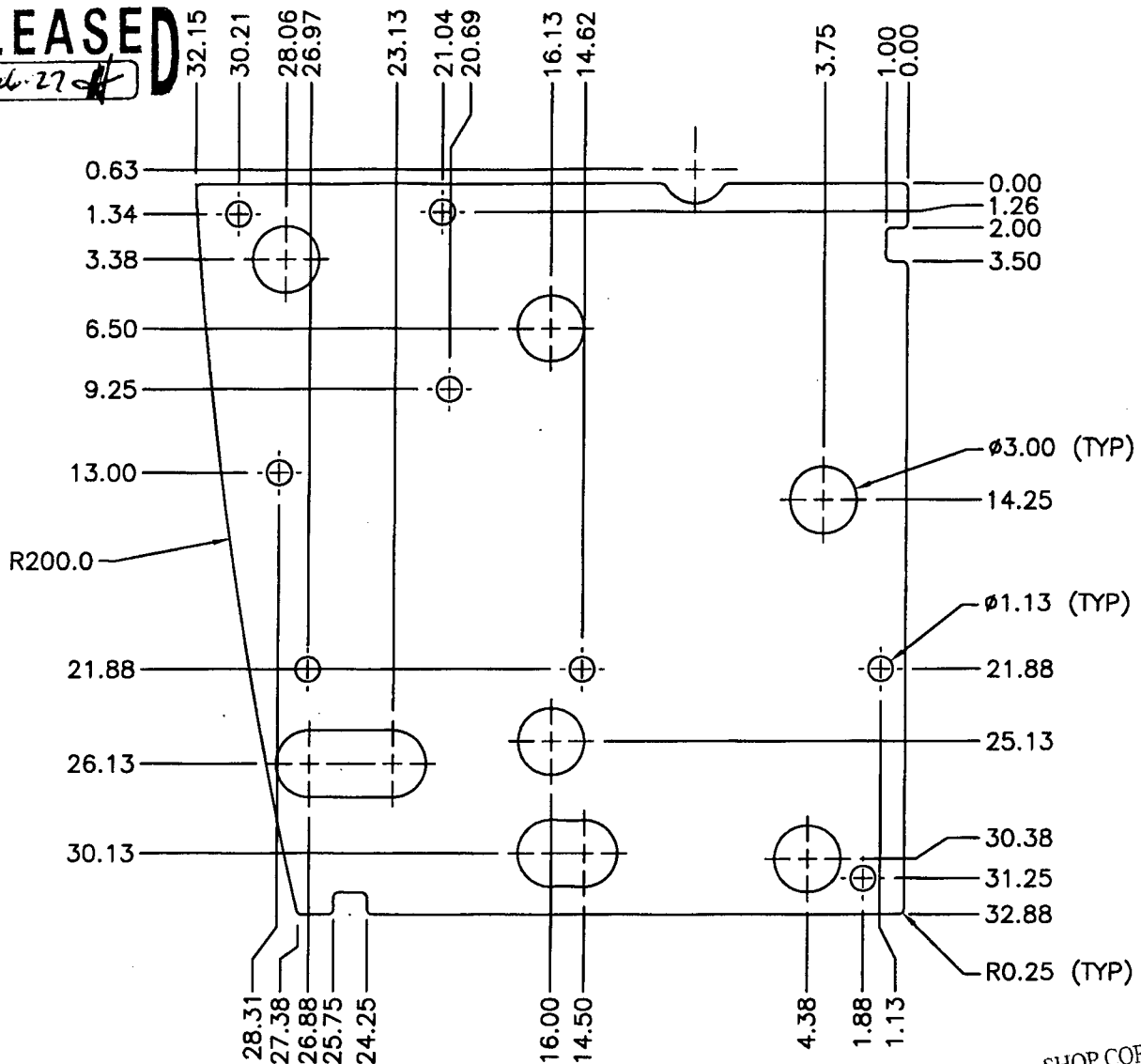
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NO. 33398

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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**  
*07-11-27***D3575-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8967

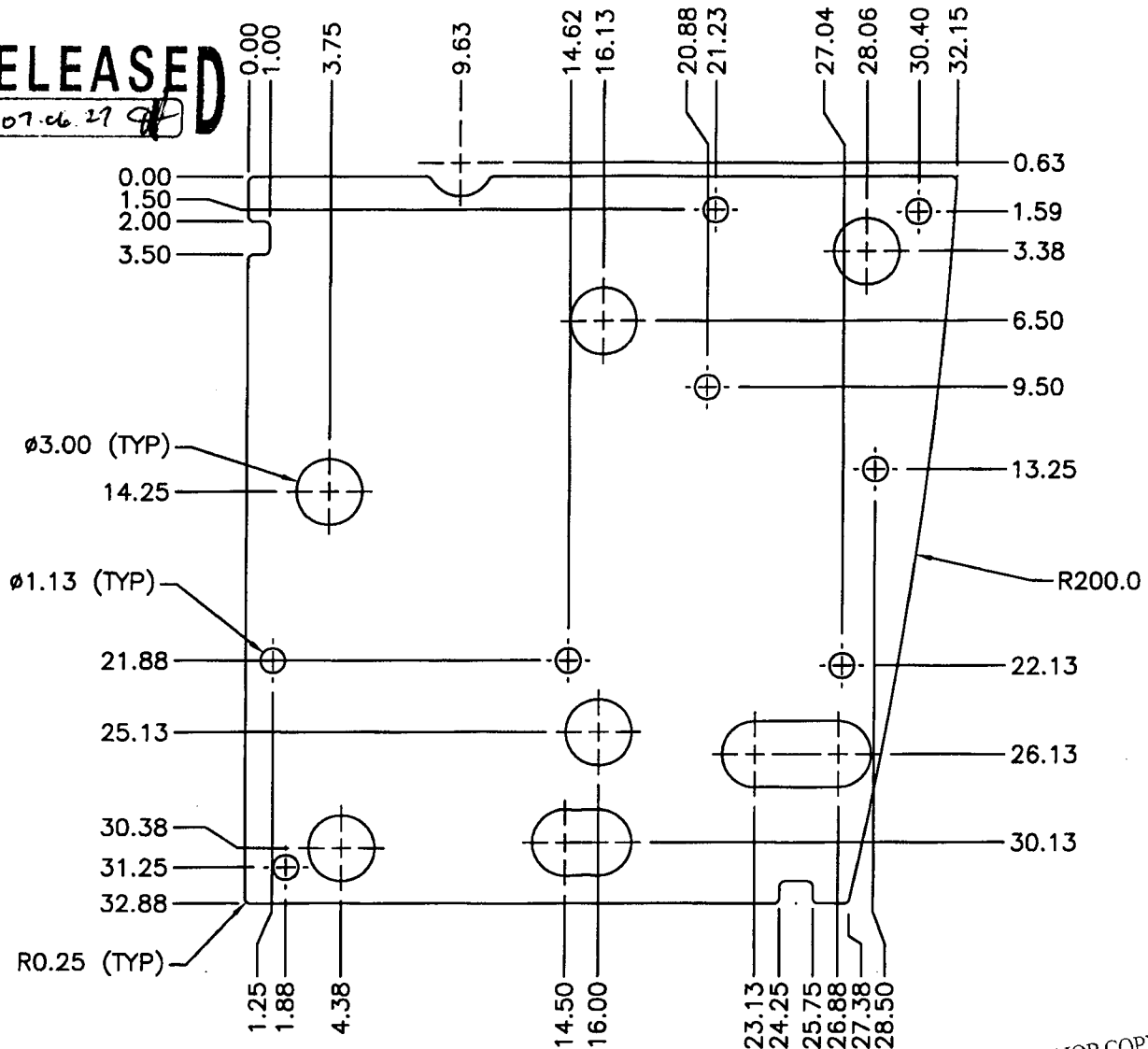
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**  
07.06.29**D3575-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8968

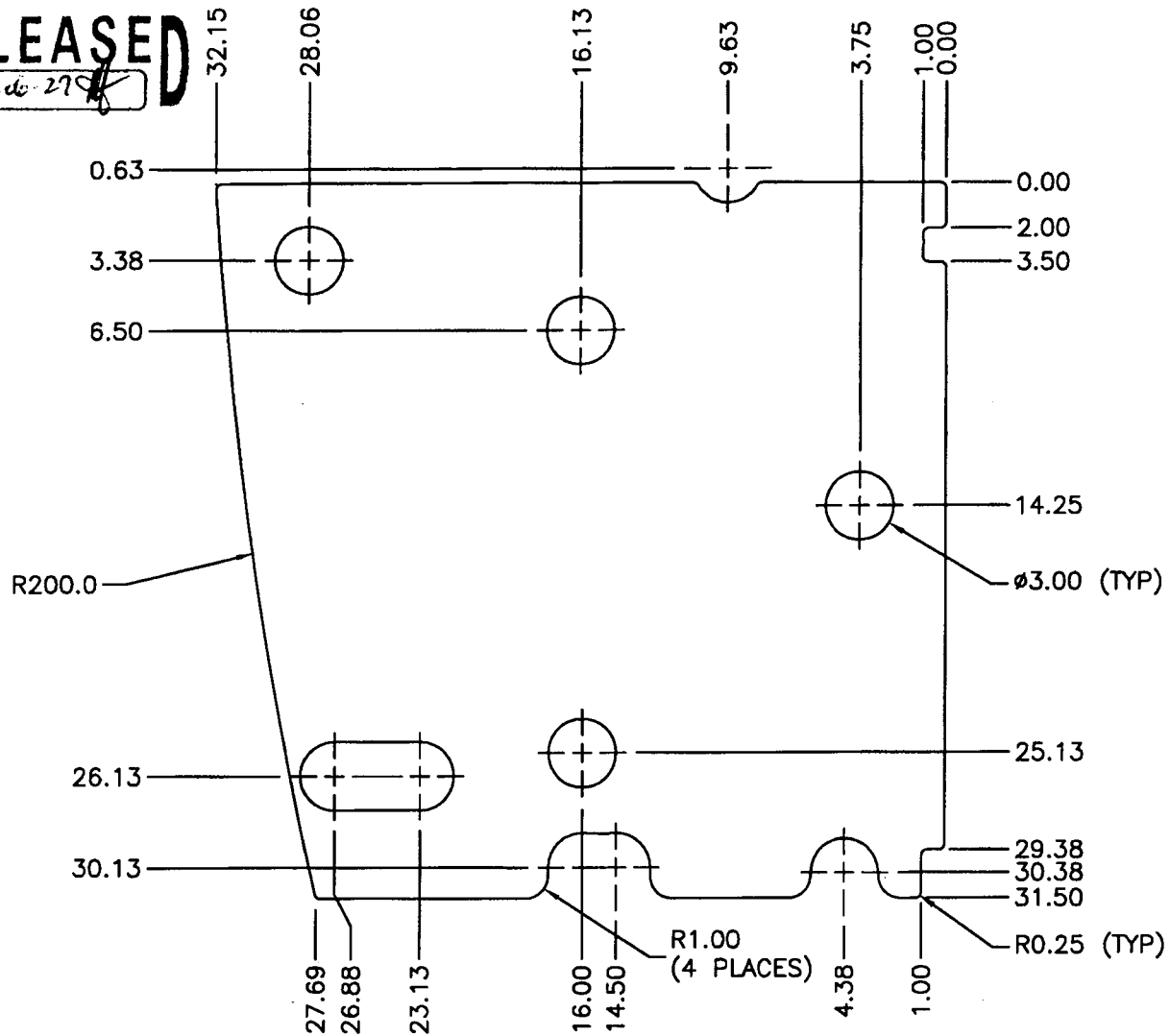
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CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3575	REV. A SHEET 4 OF 4
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:8

**RELEASED**  
07 de 279

**D3575-5 CABIN FLOOR PROTECTOR (SHOWN)**  
**D3575-6 CABIN FLOOR PROTECTOR (OPPOSITE)**

**NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3575-5/-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8969

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DART AEROSPACE LTD		Work Order: 33398
Description: CABIN FLOOR PROTECTOR		Part Number: D3575-3
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.34	+/- .030	1.34	*			
3.38	+/- .030	3.38	*			
6.50	+/- .030	6.50	*			
9.25	+/- .030	9.25	*			
13.00	+/- .030	13.00	*			
21.88	+/- .030	21.88	*			
26.13	+/- .030	26.13	*			
30.13	+/- .030	30.13	*			
1.26	+/- .030	1.26	*			
2.00	+/- .030	2.00	*			
3.50	+/- .030	3.50	*			
Ø 3.00	+ .002 - .001	Ø 3.00	*			
14.25	+/- .030	14.25	*			
Ø 1.13	+ .006 - .001	Ø 1.13	*			
21.88	+/- .030	21.88	*			
25.13	+/- .030	25.13	*			
30.38	+/- .030	30.38	*			
31.25	+/- .030	31.25	*			
32.88	+/- .030	32.88	*			

Measured by: HB	Audited by: [Signature]	Prototype Approval:
Date: 07-07-12	Date: 07/07/12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

DART AEROSPACE LTD		Work Order: 33398
Description: CABIN FLOOR PROTECTOR		Part Number: D3575-3
Inspection Dwg:	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
28.31	+/- .030	28.31	*			
27.38	+/- .030	27.38	*			
26.88	+/- .030	26.88	*			
25.75	+/- .030	25.75	*			
24.25	+/- .030	24.25	*			
16.00	+/- .030	16.00	*			
14.50	+/- .030	14.50	*			
4.38	+/- .030	4.38	*			
1.88	+/- .030	1.88	*			
1.13	+/- .030	1.13	*			
32.15	+/- .030	32.15	*			
30.21	+/- .030	30.21	*			
28.06	+/- .030	28.06	*			
26.97	+/- .030	26.97	*			
23.13	+/- .030	23.13	*			
21.04	+/- .030	21.04	*			
20.69	+/- .030	20.69	*			
16.13	+/- .030	16.13	*			
14.62	+/- .030	14.62	*			
3.75	+/- .030	3.75	*			
1.00	+/- .030	1.00	*			

Measured by: HB	Audited by: En	Prototype Approval:
Date: 07-07-12	Date: 07-07-12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	